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LOAD ACQUISITION FOR MACHINE CLAMP REGISTRIES

ABSTRACT OF THE DISCLOSURE

A method and apparatus for monitoring clamp loads used to clamp production pallets in position in a transfer machining line is disclosed. The steps include substituting a test pallet for a production pallet during a
5 production cycle. The test pallet includes at least one load cell located at a respective clamp portion. The next step is to detect when the test pallet is at the machining station and ready to be clamped. The test pallet is then clamped at its clamp portion having the load cell. Clamp load data is collected and stored in a data collector located on-board the test pallet. This
10 data may be downloaded at the end of the cycle in a readable format.

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